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D412-630-032
Job Sheet 189203



008547

Part No: D412-630-032

Job Qty: 1 pcs

Part Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 1/31/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG IIN D412-630 REV O SHEET 24, D3462 REV C IPP REV. A 05.11.21 NEW ISSUE EC IPP REV. B 05.12.19 updated pick list EC IPP REV.C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D 10.05.28 added route seq DD ver: EC IPP Rev: E 11.06.01 removed qty1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Small Fab - 1	1 pcs	1/31/19		0.00	0.31	Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	DAS
							Small Fab - 4	36
							Small Fab - 5	9-89
							Small Fab - 6	
							Small Fab - 7	
120	QC 5	1 pcs	1/31/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
130	Packaging 1-1 - Pick Kit - B4B	1 pcs	1/31/19		0.00	0.00	Packaging 1 - 1 - B4B	
							Packaging 1 - 2 - B4B	
							Packaging 1 - 3 - B4B	
							Packaging 1 - 4 - B4B	

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P.T.O.

					Packaging 1 - 5 - B4B					
					Packaging 1 - 6 - B4B					
					Packaging 1 - 7 - B4B					
					Packaging 1 - 8 - B4B					
					Packaging 1 - 9 - B4B					
					Packaging 1 - 10 - B4B					
					Packaging 1 - 11 - B4B					
					Packaging 1 - 12 - B4B					
					Packaging 1 - 13 - B4B					
					Packaging 1 - 14 - B4B					
					Packaging 1 - 15 - B4B					
					Packaging 1 - 16 - B4B					
					Packaging 1 - 17 - B4B					
					Packaging 1 - 18 - B4B					
					Packaging 1 - 19 - B4B					
					Packaging 1 - 20 - B4B					
					Packaging 1 - 21 - B4B					
					Packaging 1 - 22 - B4B					
					Packaging 1 - 23 - B4B					
					Packaging 1 - 24 - B4B					
					Packaging 1 - 25 - B4B					
					Packaging 1 - 26 - B4B					
					Packaging 1 - 27 - B4B	★ MAR 21 2019				
					Packaging 1 - 28 - B4B					
					Packaging 1 - 29 - B4B					
					Packaging 1 - 30 - B4B					
					Packaging 1 - 31 - B4B					
					Packaging 1 - 32 - B4B					
					Packaging 1 - 33 - B4B					
					Packaging 1 - 34 - B4B					
					Packaging 1 - 35 - B4B					
					140 QC 4	1 pcs	1/31/19	0.00 0.00	QC 4 - 26	
									QC 4 - 28	
									QC 4 - 38	
									QC 4 - 42	
QC 4 - 58										
QC 4 - 6										
QC 4 - 69	9-89 DAS 69									
QC 4 - 9										
150 Packaging 3-1 - Stock - B4B	1 pcs	1/31/19	0.00 0.00	QC 4 - 46	9-89 DAS 69					
				Packaging 3 - 1 - B4B						
				Packaging 3 - 2 - B4B						
				Packaging 3 - 3 - B4B						
				Packaging 3 - 4 - B4B						
				Packaging 3 - 5 - B4B						
				Packaging 3 - 6 - B4B						
				Packaging 3 - 7 - B4B						
				Packaging 3 - 8 - B4B						
				Packaging 3 - 9 - B4B						
				Packaging 3 - 10 - B4B						
				Packaging 3 - 11 - B4B						
				Packaging 3 - 12 - B4B						
				Packaging 3 - 13 - B4B						
				Packaging 3 - 14 - B4B						
				Packaging 3 - 15 - B4B						
				Packaging 3 - 16 - B4B						
				Packaging 3 - 17 - B4B						
				Packaging 3 - 18 - B4B						
Packaging 3 - 19 - B4B										
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				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
155 DC - 1 - B4B	1 pcs	1/31/19	0.00 0.00	DC - 1 - B4B	DAC 21 9-85 MAR 27 2019
				DC - 2 - B4B	
160 QC 21 - FG	1 pcs	1/31/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	DAC 21 9-85 MAR 27 2019
Part Op 110 - (Small Fab) Assemble as per IIN D412-630 ****ensure tension to retract step is 11 to 18 lbs before installing					
Descriptions: lockwire.**** A/R MS20995C41 batch: _____					
120 - (QC5- Inspect part completeness to step on W/O) ****ensure tension to retract step is 11 to 18 lbs **** Test fit on					
aircraft in Eng. lab. ENSURE STEP IS A RH: _____					
130 - (Pick Kit)					
140 - (QC4- 100% Inspect kits for completeness) VERIFY ORIENTATION OF D3462/D3463: _____					
150 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D412-630-032 ENSURE					
STEP IS A RH: _____ Location;FG034					
155 - (Document Control) Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004					
160 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN310-4 51331	Nut	1 Ea (1 ea)	110-Small Fab - 1	5082904
AN310-7 331	Nut	1 Ea (1 ea)	110-Small Fab - 1	Fm120124
AN4C14	Bolt	1 Ea (1 ea)	110-Small Fab - 1	5156687
AN4CH3 346	Bolt	2 Ea (2 ea)	110-Small Fab - 1	5158312
D3443-041 35	Strut Weldment Assembly	1 pcs (1 ea)	110-Small Fab - 1	F162502
D3443-043 35	Strut Weldment Assembly	1 pcs (1 ea)	110-Small Fab - 1	F162394
D3443-9 35	Pin	2 pcs (2 ea)	110-Small Fab - 1	5159088
D3454-7 36	Bushing	2 pcs (2 ea)	110-Small Fab - 1	F149466
D3455-1 36	Spacer	2 pcs (2 ea)	110-Small Fab - 1	5159391
D3463-042 386	Step Weldment Assembly	1 pcs (1 ea)	110-Small Fab - 1	F163925
D3465-1 37	Washer	1 pcs (1 ea)	110-Small Fab - 1	5149356
MS24665-227 289	Cotter Pin	1 Ea (1 ea)	110-Small Fab - 1	Fm135671
MS24665-302 288	Cotter Pin	1 Ea (1 ea)	110-Small Fab - 1	5156929
AN310-4	Nut	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5082904
AN310-5	Nut	2 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5101837
AN3C5A	Bolt	3 Ea (3 ea)	130-Packaging 1-1 - Pick Kit - B4B	5082907
AN44-C12	Eye Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5116568
AN4C15	BOLT	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5119359
AN5C11	Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm125722
AN5C15	Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm13833680
D3454-1	Bushing	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5077631
D3454-3	Bushing	2 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5142047
D3454-5	Bushing	2 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5142072
D3455-1	Spacer	4 pcs (4 ea)	130-Packaging 1-1 - Pick Kit - B4B	5159391
D3455-3	Spacer	2 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	F149459
D3462-042	Bracket Assembly	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5114107
D3872-5	Washer, Phenolic	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	F153354-28
MS21043-3	Nut	3 Ea (3 ea)	130-Packaging 1-1 - Pick Kit - B4B	5149144
MS24665-227	Cotter Pin	2 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm135671
MS24665-229	Cotter Pin	2 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	Fm135671
NAS1149C0363R	Washer	7 Ea (7 ea)	130-Packaging 1-1 - Pick Kit - B4B	5132665
NAS1149C0563R	Washer	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5060787
AN3C6A	Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5049457

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN310-4	1	141	0
	AN310-7	1	10	0
	AN4C14	1	11	0
	AN4CH3	2	1	0
	D3443-041	1	3	0
	D3443-043	1	3	0
	D3443-9	2	3	0
	D3454-7	2	2	0
	D3455-1	2	13	0
	D3463-042	1	2	0
	D3465-1	1	20	0
	MS24665-227	1	53	0
	MS24665-302	1	18	0
130-Packaging 1-1 - Pick Kit - B4B	AN310-4	1	141	0
	AN310-5	2	46	0
	AN3C5A	3	1,005	0
	AN3C6A	1	184	0
	AN44-C12	1	11	0
	AN4C15	1	54	0
	AN5C11	1	9	0
	AN5C15	1	7	0
	D3454-1	1	15	0
	D3454-3	2	14	0
	D3454-5	2	27	0
	D3455-1	4	13	0
	D3455-3	2	51	0
	D3462-042	1	9	0
	D3672-5	1	535	0
	MS21043-3	3	739	0
	MS24665-227	2	53	0
	MS24665-229	2	132	0
	NAS1149C0363R	7	685	0
	NAS1149C0563R	1	135	0
Part Specifications				
Specifications could not be found.				

mm
20-jun-2019



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7223

Route update only

Job: 189203		DISPOSITION		DEPARTMENT/PROCESS					
Part No. 1412-630-032		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☒ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: MAR 18 2019	Sequence #: 02-5	QTY Affected: 120		MRB (QS1042)					
Description Work Order Deviation		Disposition							
- POWDER COAT ON PART IS FLAKING OFF.		- DISASSEMBLE PART, STRIP OR SANDBLAST NON CONFORMING PART/PARTS, RE-POWDERCOAT.		Completed By 120 12-3-15 BLP-03-18. Lead hand / Supervisor					
Root Cause		DAS 68 9-89		QC / QA Coordinator DAS 68 9-89 MAR 20 2019					
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☒ Part Lost/Missing ☐ Misread ☐	